

Date: Wednesday, 12/14/2005 3:56:49 PM
 User: Kim Johnston

Process Sheet

60

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RADIUS BLOCK
Job Number : 25223	
Estimate Number : 10822	
P.O. Number : N/A	Part Number : D2274
This Issue : 12/14/2005 S.O. No. : N/A	Drawing Number : D2274 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/14/2005 Type : MACHINED PARTS	Drawing Revision : F
Previous Run : 24872	Material : N/A
Written By : <u>See comment below</u>	Due Date : 12/21/2005
Checked & Approved By : <u>See comment below</u>	Qty : 500 Um : Each
Comment : Est. H 00.05.18 Added inspection level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125"
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Comment: Qty.: 0.0962 f(s)/Unit Total: 48.0900 f(s)
 6061-T6 Bar .75" x .125"

Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" Bar Batch

M17599

En 05/12/16

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2274

En 05/12/16

506

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 05/12/16

506

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 05/12/16

506

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Tumble
 Deburr any rough edges after tumbling

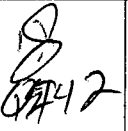
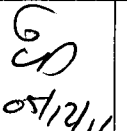

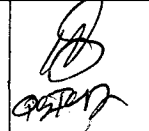
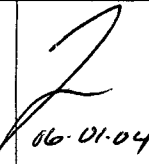
DL 05/12/20

506

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/16	2	10 PARTS SCRAP Parts popped out of Wise.	 05/12/16	Scrap and destroy and Replace	 05/12/16	 06-01-04	 05/12/16	 06-01-04

NOTE: Date & initial all entries

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Drawing Name: RADIUS BLOCK

Job Number: 25223

Part Number: D2274

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 05/12/22 506

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ML 05/12/22 506

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 35

UG/07/03 506

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUE 06/01/04 506

06/01/04 506

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/01/04
 QA: N/C Closed: _____ Date: _____

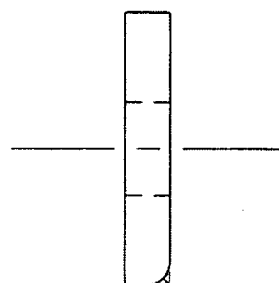
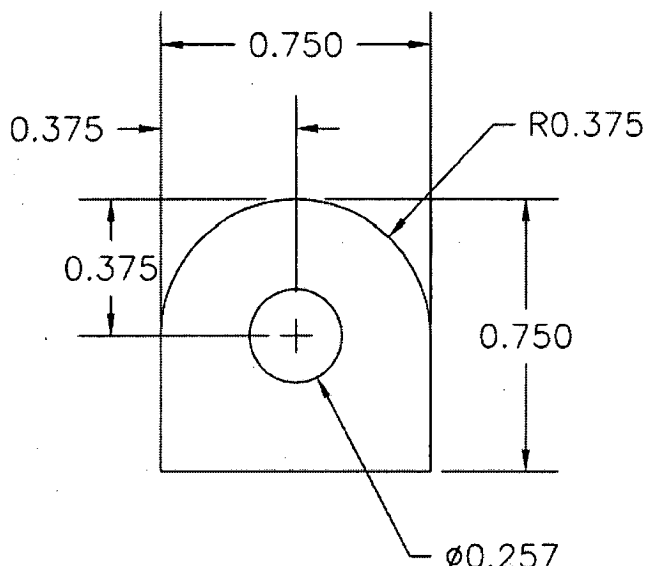
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MP	APPROVED KS	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE



0.063 x 45° CHAMFER

R0.0 - 0.13

SHOT COPY

ENGINEERING

IF USED COPY

IN ELEMENT

IN COPY

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

25223

